

**Work Order ID 85113**

Friday, June 01, 2012 4:05:08 PM

**\*85113\***

Page 1

Item ID: PB67-43001-51

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Long T-Handle Assembly

Stop **\*NS2\***

Start Date: 6/1/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *12-05-04*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

B67-43001

C

100

Weld per dwg A/R Aluminum rod Batch: *120854* 0.00  
Large Fab**\*100\***

Large Fab

Memo

0.00

Large Fab

1- drill #40 hole in center of -91 before welding -93 caps, to let air out  
2- weld -93 to -91 as per dwg  
3- grind weld flush  
4- assemble -87 under the pilot hole in -91 and weld as per dwg*1 0 12.06.06**Ae 12.06.06*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*1 0 12.06.07*

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*1 1 12.06.07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 85113

\*85113\*

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Friday, June 01, 2012 4:05:08 PM

Item ID: PB67-43001-51

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Long T-Handle Assembly

Stop \*NS2\*

Start Date: 6/1/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00

\*130\*

Small Fab

Small Fab

Memo

0.00

Small Fab

1- line drill -89 and -87 using existing pilot hole of -87 as per dwg  
2- install spring pin

①

Ø

Ae

12.06.07

140

QC5- Inspect part completeness to step on W/O

0.00

\*140\*

QC

Memo

0.00

Quality Control

Salvador

Ⓢ

150

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

\*150\*

Powdercoat

Memo

0.00

Powder Coating

\*\*\*mask prior to powder coat per dwg\*\*\*  
START TIME: 8:15  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 8:45

1X

M-F

12/06/13

M18144

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 85113****\*85113\***

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Friday, June 01, 2012 4:05:08 PM

Item ID: PB67-43001-51

Accept

**\*N9000040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Long T-Handle Assembly

Start Date: 6/1/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

1

4/12/13

170

Identify as per dwg & Stock Location: PAS

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

1

S.C. 12/06/13

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/6/14

MCS 12/06/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Friday, June 01, 2012 4:05:08 PM

Page 1

Work Order ID: 85113

Parent Item: PB67-43001-51

Parent Item Name: Long T-Handle Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-25 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-87 Tube Arm		Manufactured	No			100	Each	5.0000	1	1		12.06.05 Ae	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST209a		5							
				53245		5							
PB67-43001-91 Tube Handle		Manufactured	No			100	Each	8.0000	1	1		12.06.05 Ae	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST444		8							
				41519		8							
PB67-43001-93 Tube End Cap		Manufactured	No			100	Each	24.0000	2	2		12.06.05 Ae	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST445		24							
				41520		24							
240-107 SPRING SLOTTED PIN		Purchased	No			130	Each	82.0000	1	1		12.06.05 Ae	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST400		82							
				115827		82							
PB67-43001-89 Clevis		Manufactured	No			130	Each	9.0000	1	1		12.06.05 Ae	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST444		9							
				23986		8							
				100078		1							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

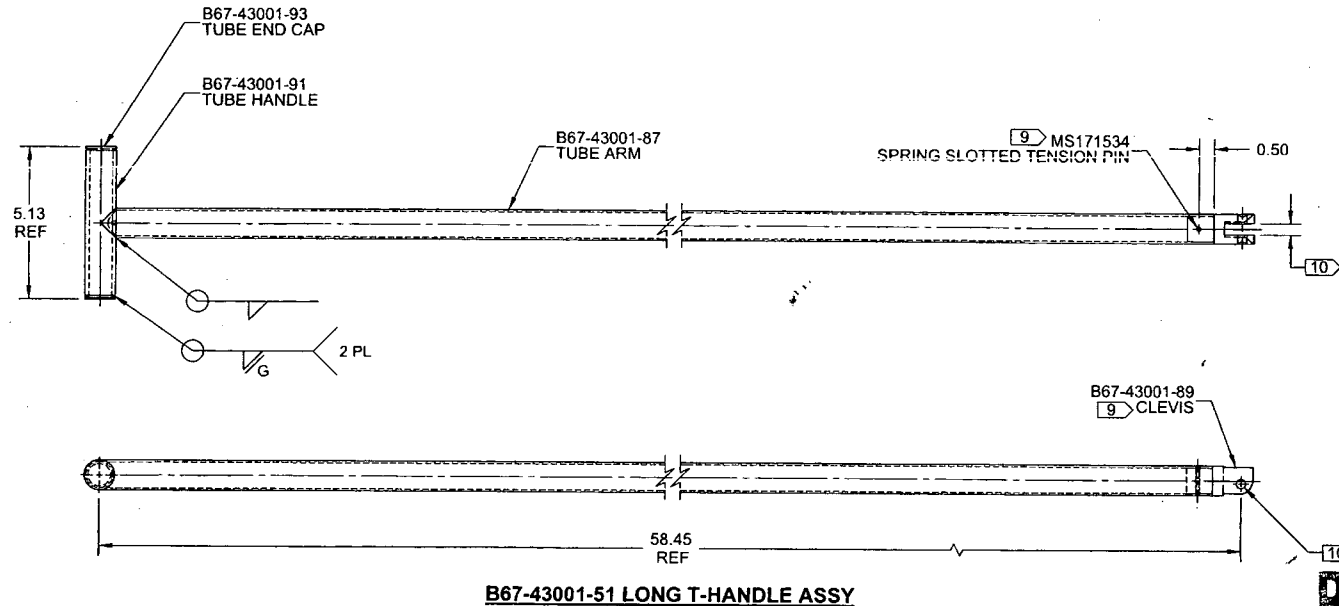
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM	QTY -19	P/N	DESCRIPTION
1	X	B67-43001-51	LONG T-HANDLE ASSY
3	1	B67-43001-87	TUBE ARM
4	1	B67-43001-89	CLEVIS
5	1	B67-43001-91	TUBE HANDLE
6	2	B67-43001-93	TUBE END CAP
8	1	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)



**RELEASED**  
2009-09-24

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.35 lbs
- 8) WELDING: PER QSI 004
- 9) PRIOR TO POWDER COAT, ALIGN B67-43001-89 ON B67-43001-87 AS SHOWN AND DRILL A  $\varnothing 0.129$  HOLE THROUGH BOTH PARTS AND FASTEN B67-43001-89 TO B67-43001-87 USING MS171534 SPRING SLOTTED PIN
- 10) MASK PRIOR TO POWDER COAT

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 13 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.06.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN	AS		
CHECKED	AS		
MFG. APPR.	AS		
APPROVED	AS		
DE APPR.	N/A		
DATE	09.06.25		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>B67-43001-51</b>	REV. C
TITLE <b>LONG T-HANDLE ASSY</b>	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries